

Work Order ID 81983

March-21-12 1:54:58 PM

81983

Page 1

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 24/03/21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2650	F								

100

0.00

100

DOCUMENT CONTROL

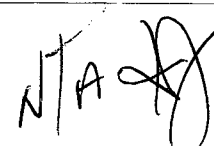
DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

NTA 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/RAluminum Rod *M120164*

4-Grind weld flush to cap on top surface only.

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

STB 12-03-23

3 BE 12-03-27

SAD 12-03-28

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

125

QC7-Inspect Chemical Conversion Coat

0.00

125

QC

Memo

0.00

Quality Control

8/12/12/28

① B 12/03/28

JP 12-3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Setup

Start

NS1

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NS2

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Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Skidtubes

0.00

Skidtubes

Memo

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 12-3-28 Time: 16:00

Finish Date: 12-3-29 Time: 8:00

A/RSikaflex-291 m120813

Sikaflex expiry date: 12-08-13

BB 12/03/28

CF 12.3.28

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

1 0 BE 12/03/29

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/RAluminum Rod <i>m120164</i>								
	2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube								
	3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr								
	4- Install nut plate as per dwg								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

BE 12/03/29

ET/CC 12/4/2

Sr12/4/103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March-21-12 1:54:58 PM

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Page 6

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N900040100Setup Start ***NS1***

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Item Name: Replacement Skidtube

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

6/12/04/03

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

IX 12/04/04

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2h 30
OVEN TEMPERATURE: 320°F
FINISH TIME: 3h 00

m 12/02/22

1 12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 7

March-21-12 1:54:58 PM

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NS1

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Stop

NS2

Item Name: Replacement Skidtube

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

1 6 21 12/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 8

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Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>126318</u> Sikaflex expiry date: <u>12/08</u>					1	8	(2A) BR	12/04/12
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive								PTO →
	3-Install MS27039-4-06 Screw								
	4-Inspect for foreign object per QSI 024								
	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 <u>120318</u> Sikaflex expiry date: <u>12/08</u>								
	6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: <u>120902</u>								

Dart Aerospace Ltd

W/O: 81983		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/04/12	220	As Per Detail "E" Drawing End CHP Assemble w MS27039-1-08 Screws. Batch 121011	DP	12/04/12	2		

Part No: D206-642-341 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 81983

March-21-12 1:54:58 PM

81983

Page 9

Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Replacement Skidtube
Start Date: 21/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 04/04/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00				1	0		all 12/04/12
Quality Control									
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Packaging	0.00							
250									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-341								
	Location: _____								
	PPP Rev: _____								

PP

81988

12/5/388

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 81983

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Page 10

March-21-12 1:54:58 PM

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 Required Date: 04/04/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

12-05-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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March-21-12 1:55:01 PM

81983

D206-642-341

Required Date: 04/04/2012

Required Qty: 1.00

IPP Rev: H05.10.11Added D3429-1 per CHG004KJ/CP/JLM
 IPP Rev: I 08-09-29 rev F as per dwg DD verified by: EC Est Rev: J 09-
 03-02 as per DS19440 rev. a DD verified by: EC IPP rev K 10.08.03 chg
 ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416 Washer	NAS1149D0463J	Purchased	No		116289 121255		Each	14.0000		1		12/04/12	
AN960.ID416													
**													
<div>Location</div> <div>ST351</div> <div>116289</div>													
<div>Loc Qty</div> <div>14</div> <div>14</div>													
<div>Loc Code</div> <div></div> <div></div>													
CCR264SS3-3 Cherry Rivet		Purchased	No				Each	581.0000		2			
CCR264SS3-3													
**													
<div>Location</div> <div>ST331</div> <div>113973</div> <div>117849</div> <div>119017</div>													
<div>Loc Qty</div> <div>581</div> <div>2</div> <div>111</div> <div>468</div>													
<div>Loc Code</div> <div></div> <div></div> <div></div> <div></div>													
CR3212-4-03 Cherry Rivet		Purchased	No				Each	1,438.000		2			
CR3212-4-03													
**													
<div>Location</div> <div>FP002</div> <div>114859</div> <div>ST331</div> <div>110139</div> <div>119017</div>													
<div>Loc Qty</div> <div>448</div> <div>448</div> <div>990</div> <div>2</div> <div>988</div>													
<div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div>													

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-21-12 1:55:01 PM

Page 2

Work Order ID: 81983

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

81983

D206-642-341

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

24.0000

1

D2620

Skidtube, 206 Skidtube

**

12-03-22

Location

Loc Qty

Loc Code

LG

24

77999

1

79543

2

79544

2

79545

1

81365

10

81366

8

D2647

Manufactured No

Each

43.0000

1

D2647

Cap

**

8612-03-27

Location

Loc Qty

Loc Code

LG002

43

75482

43

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 3

March-21-12 1:55:01 PM

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81983

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

Each

1,360.000

19

D2649

Cross Bolt Spacer

**

BE 12/03/29

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	903	
77574	2	
79502	403	<i>19</i>
79503	399	
79565	99	
LG001	457	
65317	1	
68224	2	
68507	11	
71355	2	
72704	2	
72841	11	
73390	8	
73857	21	
73858	53	
73859	4	
73860	4	
78020	6	
78583	2	
79566	330	

D2654-5

Manufactured No

Each

12.0000

1

D2654-5

Web

**

D CF 12-3-28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	12	
80057	6	
81326	6	

March-21-12 1:55:01 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:01 PM

Work Order ID: 81983

81983

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each

144.0000

D2680-041

Nut Plate

**

1
CC/AD

Location

Loc Qty

Loc Code

ST013

116

78016

116

ST019

28

76790

28

MS27039C1-08

Purchased

No

Each

1,594.000

MS27039C1-08

SCREW

**

①

56

56

SP

12/04/12

Location

Loc Qty

Loc Code

FP002

1

116022

1

ST292

1500

120308 ✓

1000

121068

500

ST293

93

116373

3

118077

14

119309

76

ALS4-1032-130

Purchased

No

220

Each

4,213.000

54

AI S4-1032-130

Insert

**

54

54

SP

12/04/12

Location

Loc Qty

Loc Code

ST280

283

119084

116

120671

167

ST281

3930

120807 ✓

1930

120837

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:01 PM

Work Order ID: 81983

81983

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

* NAS1149C0332 Purchased

No

121255 ✓ 220

Each

0.0000

54

54

*AN960C10I *

washer

**

51 (28) 12/04/12

AN960JD10L

* NAS1149D0332J Purchased

No

220

Each

0.0000

2

2

*AN960.ID10I *

Washer

**

2 (28) 12/04/12

D2646

Manufactured

No

220

Each

118.0000

1

1

D2646

Aft Cap

**

1 (28) 12/04/12

Location

Loc Qty

Loc Code

FP002

118

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

24

79500

33

79562 ✓

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:01 PM

Page 6

Work Order ID: 81983

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

81983

D206-642-341

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

220

Each

505.0000

14

14

*D2651-1**

Plug

**

10 12/04/12.
4 12/04/12.

Location

Loc Qty

Loc Code

FP001 81809✓ 799
57869 1
66445 81954✓ 10
69018 2
70827 2
70839 8
71037 8
77559 30
78584 188
79234 250
FP-A -294
77559 1
78124 5

D2651-3

Manufactured No

220

Each

1,860.000

14

14

D2651-3

O-Ring

**

14 12/04/12.

Location

Loc Qty

Loc Code

FP001 16
61962 12
73828 4
FP-A 1844
78126✓ 1844

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:01 PM

Page 7

Work Order ID: 81983

81983

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-11 Manufactured No

220 Each

21.0000 1 1

D3535-11

Wearshoe

**

1 (SP) 12/04/12

Location

Loc Qty

Loc Code

FP001

21

71284

6

79058 ✓

15

D3535-23 Manufactured No

220 Each

28.0000 1 1

D3535-23

Wearshoe

**

1 (SP) 12/04/12

Location

Loc Qty

Loc Code

FP001

28

74508 ✓

10

80330 ✓

18

D3535-35 Manufactured No

220 Each

25.0000 1 1

D3535-35

Wearshoe

**

1 (SP) 12/04/12

Location

Loc Qty

Loc Code

FP001

25

67598

1

70815

1

78873

13

79849

1

80332

9

81358 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:01 PM

Work Order ID: 81983

81983

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-11	Manufactured	No	220	Each	28.0000	1	1
D3536-11						**	1 (2P) 12/04/11
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	28	
46649	1	
46715	4	
65574	1	
80006 ✓	22	

D3536-23	Manufactured	No	220	Each	36.0000	1	1
D3536-23						**	1 (2P) 12/04/11
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	36	
43406	1	
74510	9	
80334 ✓	26	

D3536-35	Manufactured	No	220	Each	25.0000	1	1
D3536-35						**	1 (2P) 12/04/11
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	25	
80335 ✓	25	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:01 PM

Page 9

Work Order ID: 81983

81983

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

220

Each

96.0000

6

6

D3537-1

Wearpad

**

6

(2P)

12/04/11

Location

Loc Qty

Loc Code

FP001

91

79833

37

79835

54

FP002

5

69817

5

D3537-3

Manufactured No

220

Each

7.0000

1

1

D3537-3

Wearpad

**

1

(2P)

12/04/11

Location

Loc Qty

Loc Code

FP002

7

74500

2

76986

5

MS27039-4-06

Purchased No

220

Each

183.0000

1

1

MS27039-4-06

Screw

**

1

(2P)

12/04/11

Location

Loc Qty

Loc Code

ST292

183

119075

183

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81983

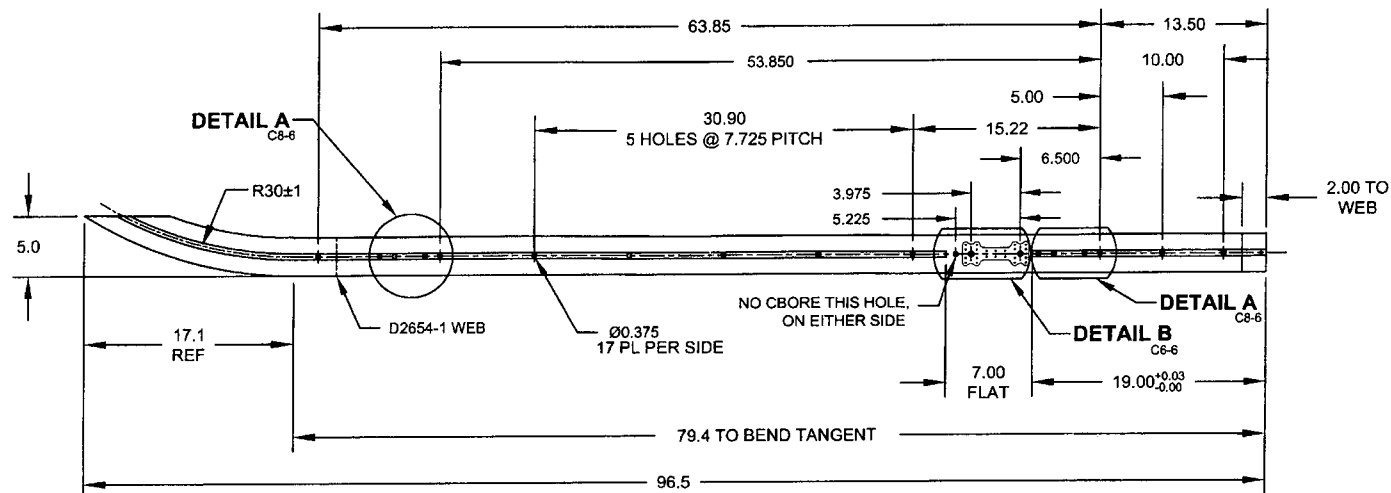
112-03-21

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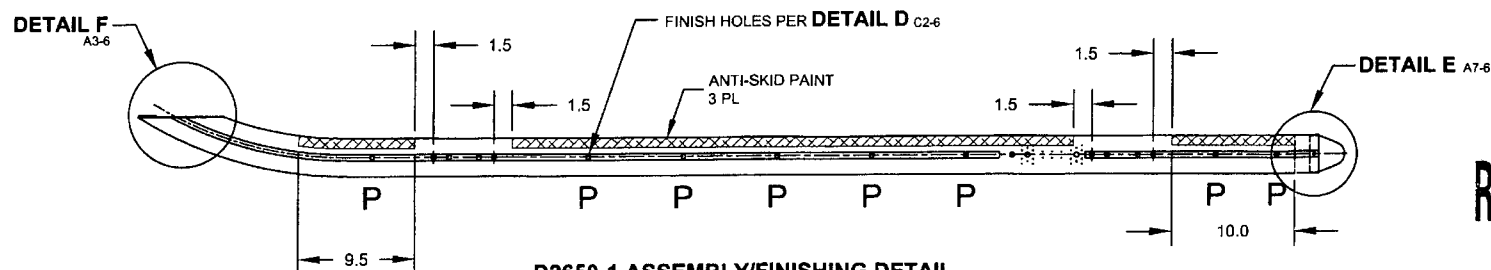
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2650-1 BENDING/DRILLING DETAIL

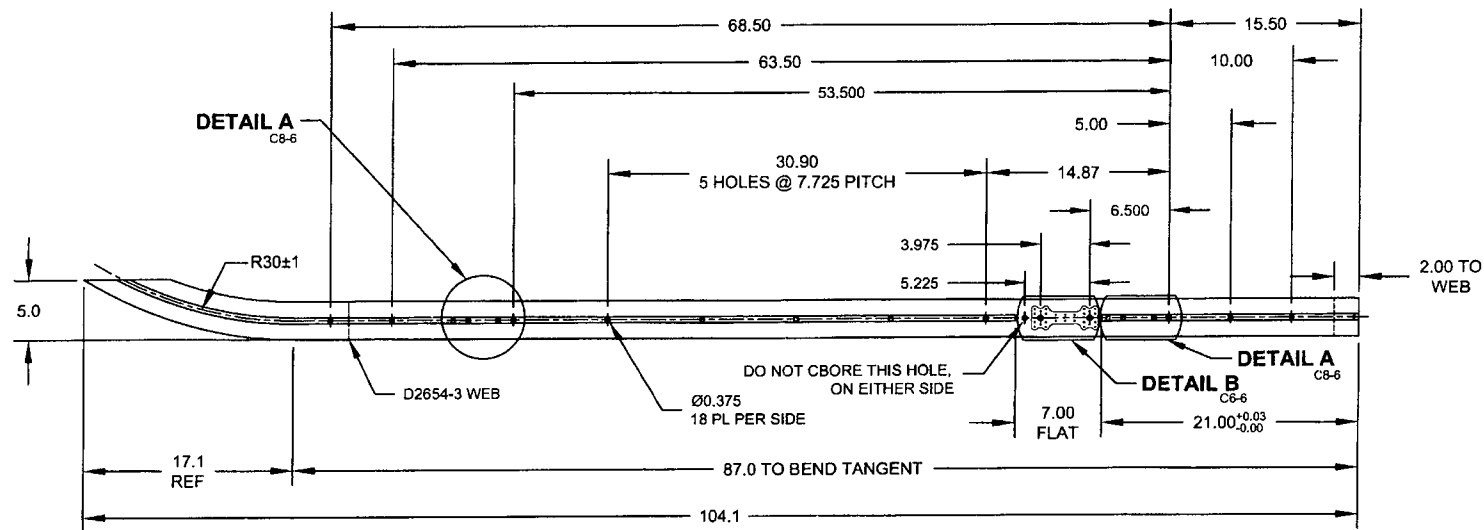


D2650-1 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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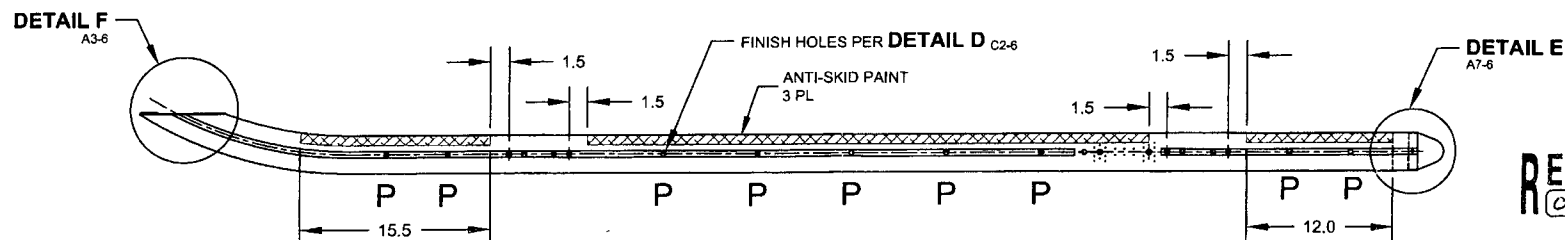
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680922/117

81283



D2650-3 BENDING/DRILLING DETAIL

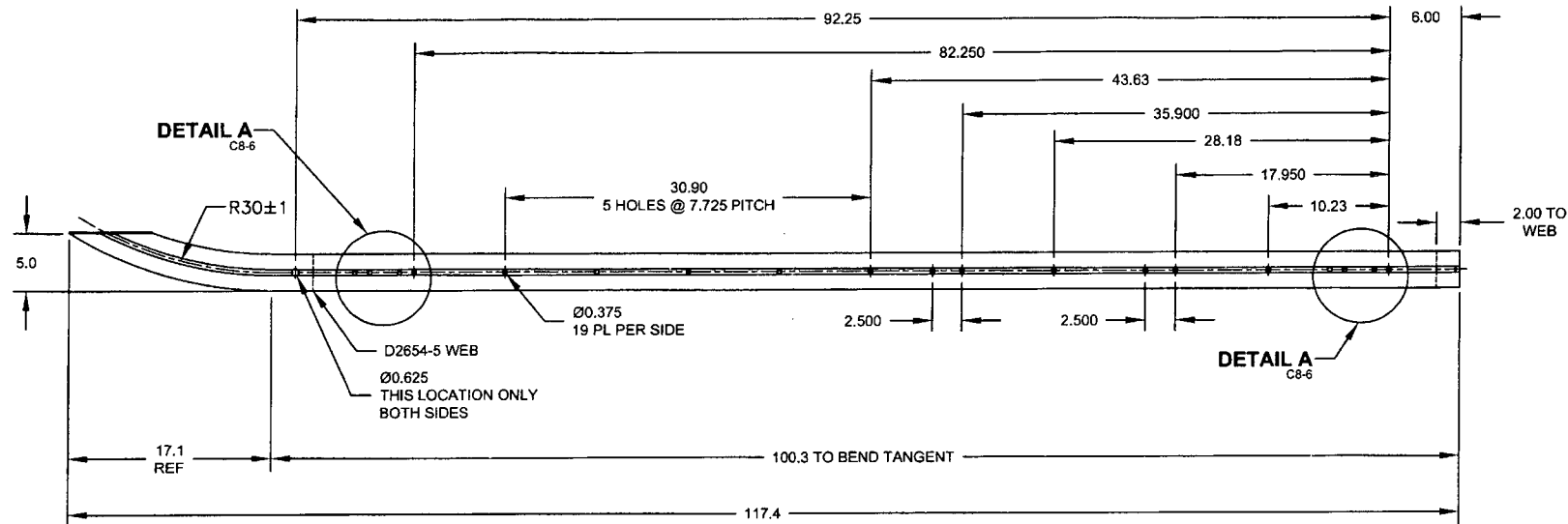
8/28/83



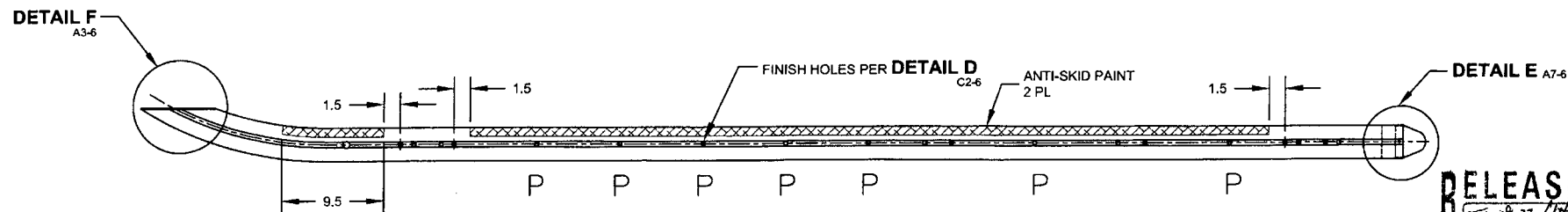
D2650-3 ASSEMBLY/FINISHING DETAIL

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08-07-22-100

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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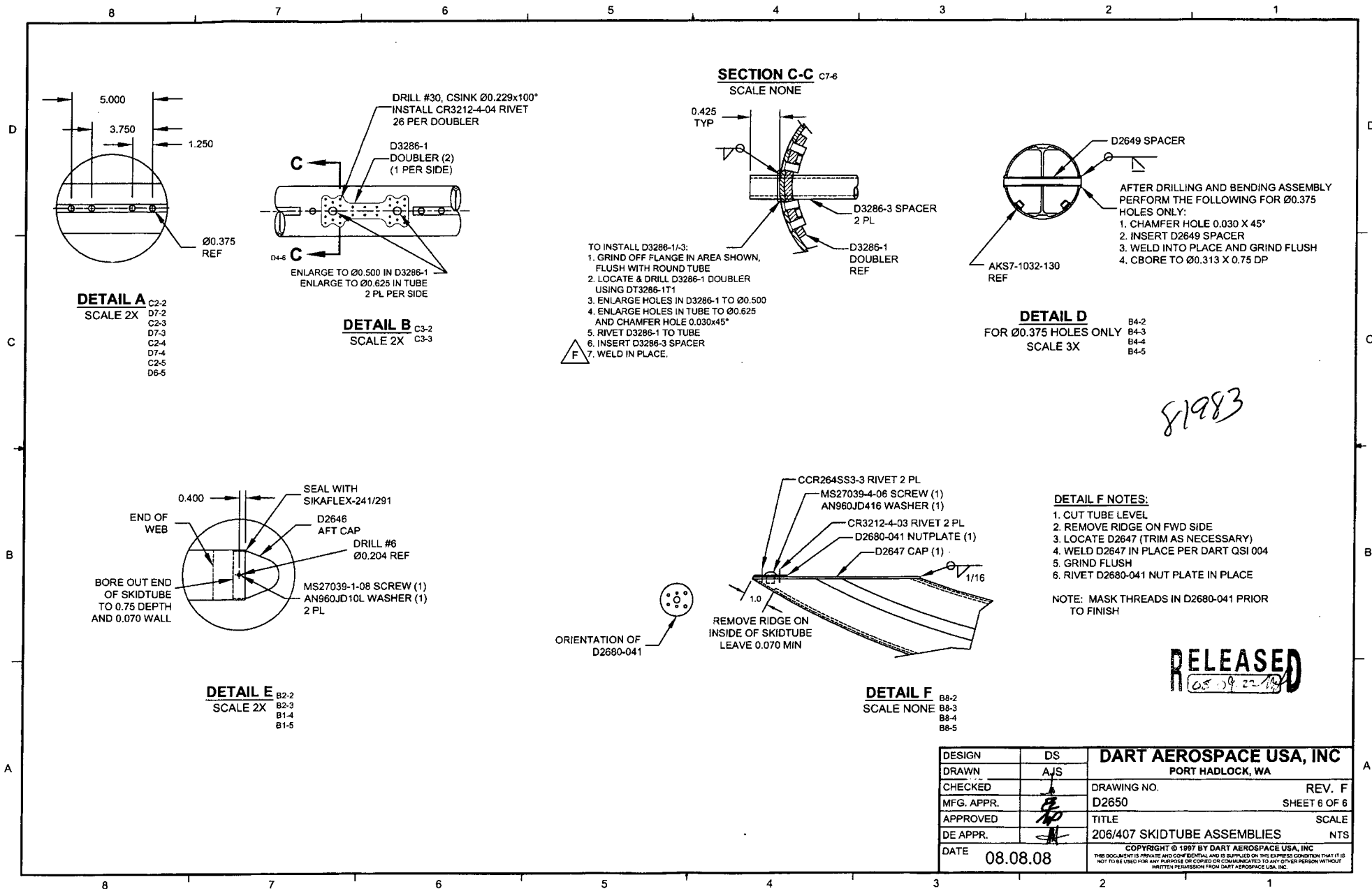
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AP/S	PORT HADLOCK, WA	
CHECKED	<i>J</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>AP</i>	D2650	SHEET 4 OF 6
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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RELEASED



NO. 287

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 796517
Part number: A206-646-341
Description: Skid tube
Welding Process: Tig[☒] Mig[☐]
Base material: Alum
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[☐]
Penetration: pass[☒] fail[☐]

UNACCEPTABLE

Cracks: pass[☒] fail[☐]
Undercut: pass[☒] fail[☐]
Pin holes: pass[☒] fail[☐]
Overlap (cold lap): pass[☒] fail[☐]
Porosity (surface): pass[☒] fail[☐]
Coloration: pass[☒] fail[☐]

Qualifier David Hand Date of Test Coupon 12-04-03
Welder Barclay Elliott Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld